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(54) Title: WHEELS OF SINGLE COMPONENT CONSTRUCTION AND METHOD OF MAKING SAME

(57) Abstract: This invention relates to a unitary steel wheel as well as the apparatus and method of producing a unitary steel wheel. The unitary wheel comprises wheel rim and disc portions. In one embodiment, the unitary wheel of this invention further comprise a one-piece wheel of 5° and 15° dorp center rims, providing a generally circular steel blank from a sheet stock of pre-determined substantially uniform thickness. The bank preferably has a center hole having a predetermined size. The blank is performed in a spinning machine to a predetermined profile and shape. The perform is further spun and flow formed in a spinning machine, the perform being positioned between an outer roll and inner mandrel and held against a clamping plate. The inner mandrel comprises an outboard surface, which conforms to the predetermined inner diameter of the rim. The perform is further processed in the spinning machine to form a final shape and profile of the rim portion comprising a well, inner and outer flange portions, and inner and outer bead-seat portions.



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